

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017402**Date Inspected:** 09-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.Geng wei/Li Shi You**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG Segment 13BE.

SEG3009-006, 008

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 13 West Line, weld No: SEG3014A-009. The welder is identified as #067904. ZPMC CWI is identified as Mr.Wang Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector observed the following work in progress:

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SMAW in the 4G position for the OBG Segment 13 West Line, weld No: SEG3014A-007. The welder is identified as #045246. ZPMC CWI is identified as Mr. Wang Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 13 West Line Side Panel, weld No: OBW13C-002. The welder is identified as #066326. ZPMC CWI is identified as Mr. Wang Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1. Please see the attached picture.

Bay #16

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 13AW, weld No: LD3031-001-160. The welder is identified as #045280. ABF QA is identified as Mr. Li Shi You. The welding variables recorded by QC appear to comply with WPS-B-T-2233-TC-U5-F.

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 13AW, weld No: LD3034-001-149. The welder is identified as #040344. ABF QA is identified as Mr. Li Shi You. The welding variables recorded by QC appear to comply with WPS-B-T-2233-TC-U5-F.

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13CW, Weld No: BP3056-001-063/064. The welder is identified as #070234. ZPMC QC is identified as Mr. Liu Dao Feng. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Visual Inspection after Blast

Segment 11DE

During random Quality Assurance visual inspection after the grit blast of the segment 11DE, this Quality Assurance Inspector (QA) discovered the following issue:

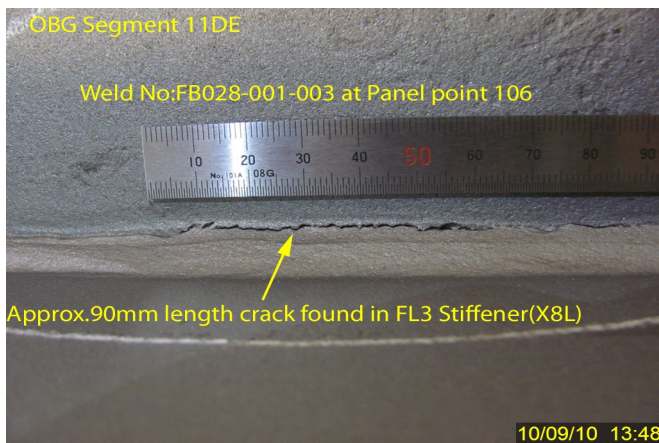
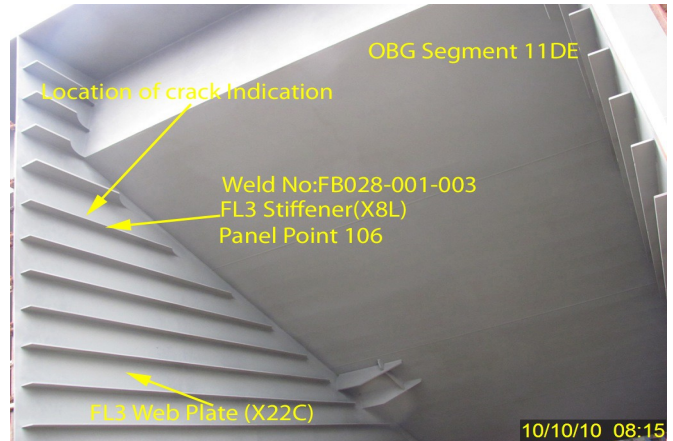
- One Longitudinal Crack indication in the weld measuring approximately 90mm in length @ panel point 106.
- The weld is identified as FB028-001-003.
- Y location is approx. 900mm, measured from the termination of the weld on the Cross Beam side.
- This weld is Fillet weld joining the FL3 Floor beam Web Plate (X22C) to Stiffener (X8L).
- This weld joint is designated as Non-Seismic performance critical (Non-SPCM) weld member.
- The indication is clearly marked on or the weld.
- The Segment 11DE is located inside the Paint Shop #01.

For further information, please see the attached pictures below.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Pandaram

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer